

Work Order ID 128982

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128982

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Item ID: D4779-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Cover Mounting Bracket Assembly
 Start Date: 1/26/15 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4779	A

100	FLOW WATER JET	0.00							
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100

Waterjet Memo 0.00 (16) 12/15/02/08

FLOW CNC Waterjet

6001.032

1-Cut D4779-1 as per Dwg
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110

QC Memo 0.00 (16) 12/15/02/08

Quality Control

120	QC8- Inspect parts - second check	0.00							
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120

QC Memo 0.00 (16) 12/15/02/08

Quality Control

DAS
38
9-89

FEB 09 2015

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FEB 11 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						16	0	15-2-12	DAS 34 9-89
HandFinish	Memo	0.00							
Hand Finishing									
165	QC7-Inspect Chemical Conversion Coat	0.00							
165						16x	0	15/02/17	DAS 34 9-89
QC	Memo	0.00							
Quality Control									
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170						16	0	15-2-17	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:30 OVEN TEMPERATURE: 320° FINISH TIME: 4:00								

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: 5107	0.00				16	DAS		
210							06		
Packaging	Memo	0.00					9-89		FEB 21 2015
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

15/2/23
MF
15-2-23

Picklist Print

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Parent Item: D4779-041

D4779-041

Parent Item Name: Aft Cover Mounting Bracket Assembly

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 13.03.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased			No	100	sf	267.6767	0.058	1			

M6061T6S 032

6061-T6 Sheet 0.032"

DC 15/02/08

Location	Loc Qty	Loc Code
MAT021	267.6767	
m130387	61.6667	
m130585	62.01	
m131352	144	

MS20426AD3-4

Purchased No

MS20426AD3-4

RIVET

DAS
30
9-89

15/02/09

Each 2,154.000

64

DAS
28
9-89

FEB 19 2015

Location	Loc Qty	Loc Code
CA	12	
125578	12	
GA	1736	
m127432	1736	
MF4	36	
125578	36	
ST313	370	
125578	370	

MS21059L3

Purchased

No

MS21059L 3

Nut Plate

Each 122.0000

32

DAS
28
9-89

Location	Loc Qty	Loc Code
CA	16	
M129682	16	
GA	106	
M130823	106	

32

8

7

6

5

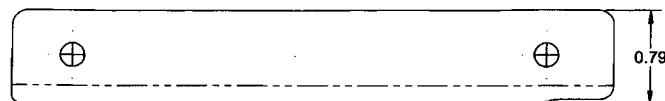
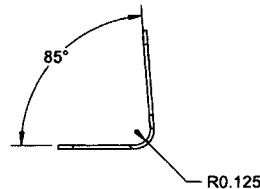
4

3

2

1

QTY -041	P/N	DESCRIPTION
X	D4779-041	AFT COVER MOUNTING BRACKET ASSY
1	D4779-1	AFT COVER MOUNTING BRACKET
4	MS20426AD3-4	RIVET, CSK
2	MS21059L3	NUTPLATE



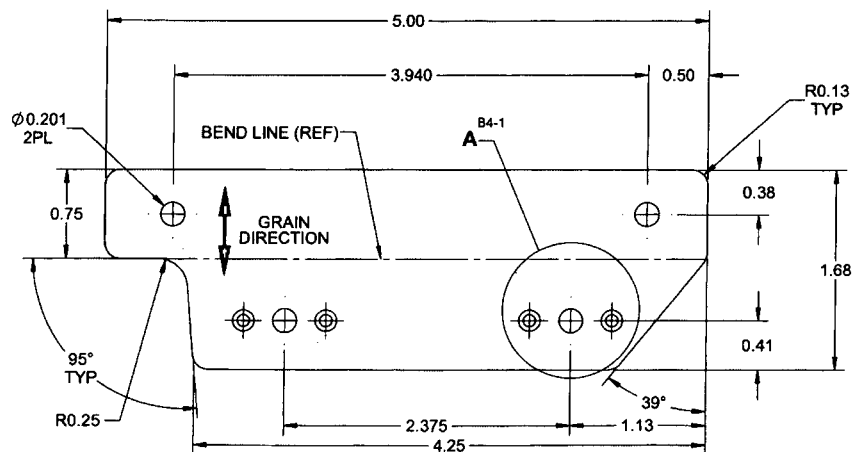
D4779-1 AFT COVER MOUNTING BRACKET
(MAKE FROM D4779-1F)

D4779-1 AFT COVER
MOUNTING BRACKET

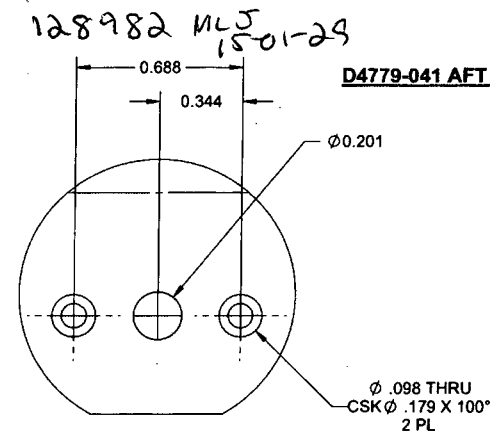
MS21059L3
NUTPLATE
2 PL



MS20426AD3-4
RIVET, CSK
2X, 2 PL



D4779-1F FLAT PATTERN



DETAIL A B6-1
NUTPLATE HOLE PATTERN
2 PL

RELEASED
2013-03-11

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032" THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF. DART SPEC. M6061T6S.032)
- 2) FINISH: D4779-1F: NONE, D4779-1: CHEMICAL CONVERSION COATING PER DART QSI 005 4.1, POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3, D4779-041: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4779-041" AND B/N USING FINE POINT MARKER PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PROFILE PER DRAWING FILE "D4779-1F-REVA.DXF"

A	NEW RELEASE	DB	13.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	R.V.	DRAWING NO.	REV. A
MFG. APPR.		D4779	SHEET 1 OF 1
APPROVED		TITLE	AFT COVER MOUNTING BRACKET ASSY
DE APPR.		SCALE	NTS
DATE	13.03.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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